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Fig.1

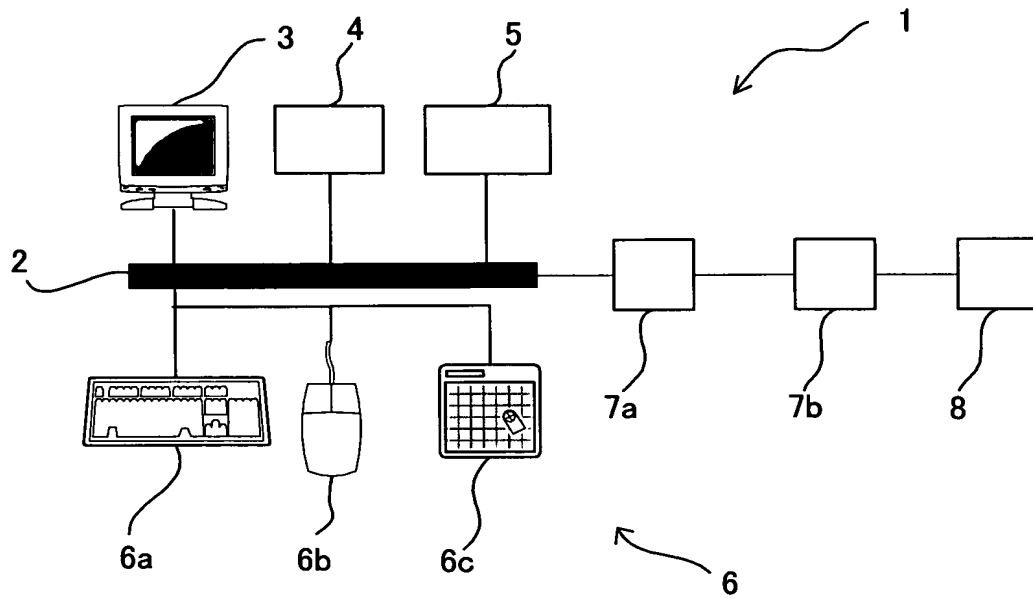
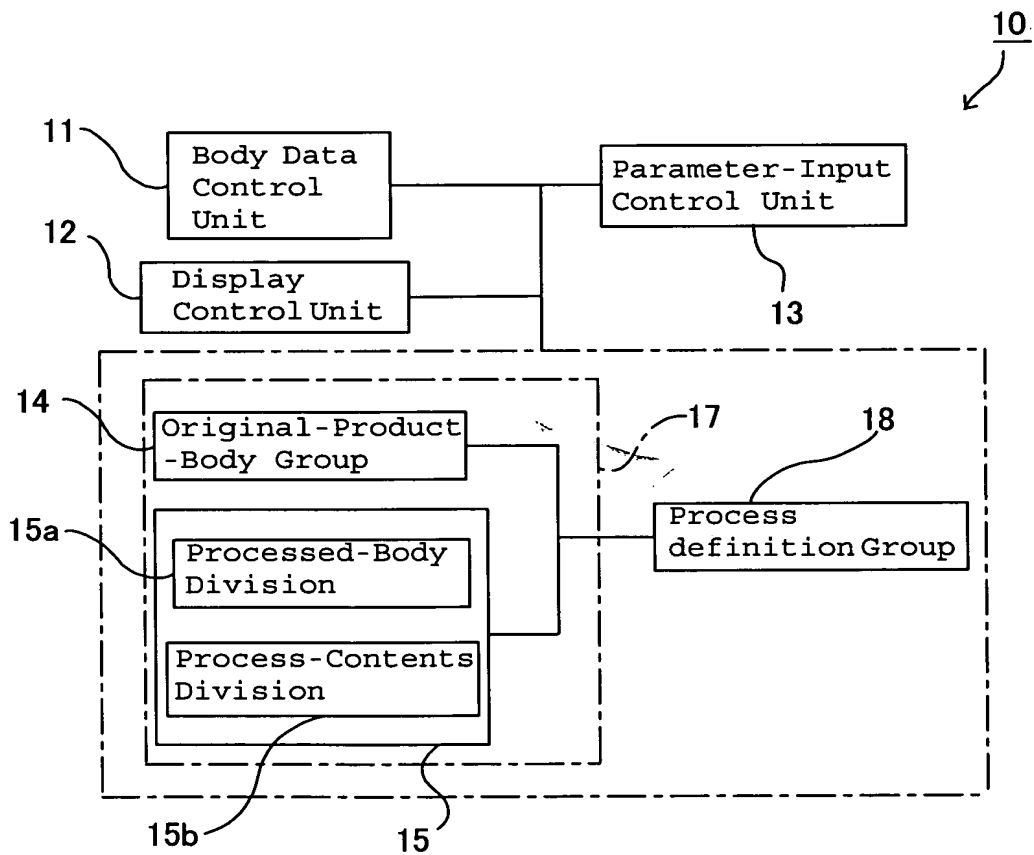
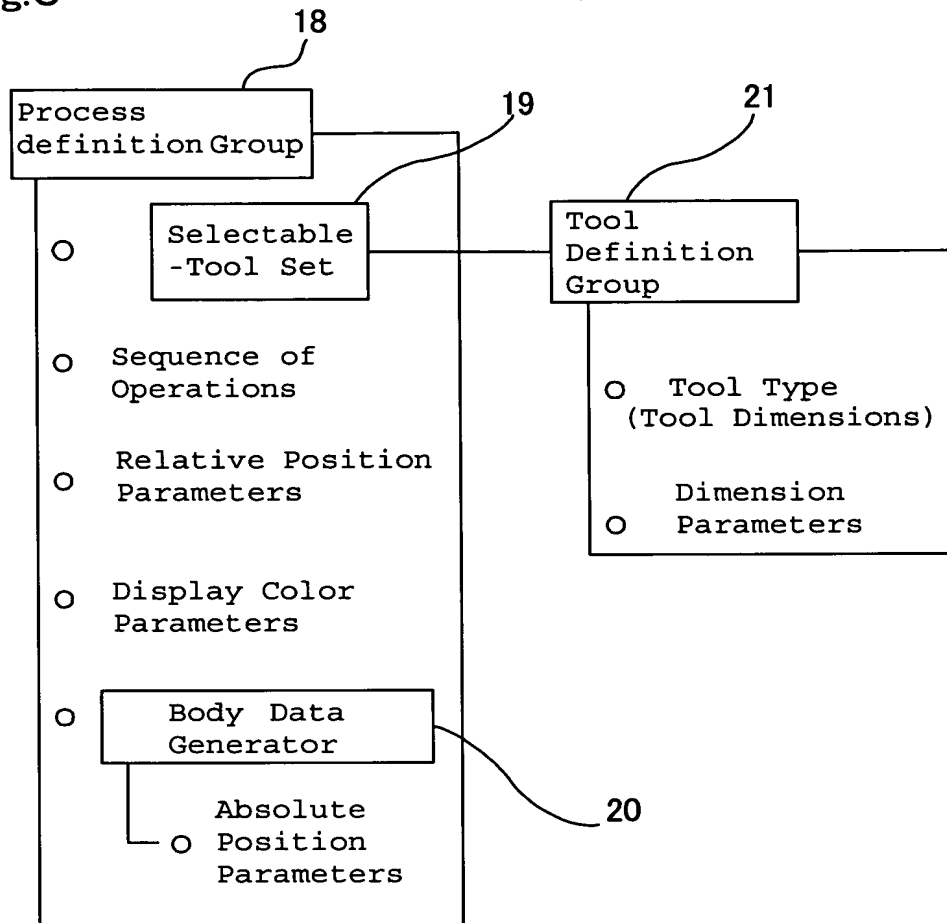


Fig.2



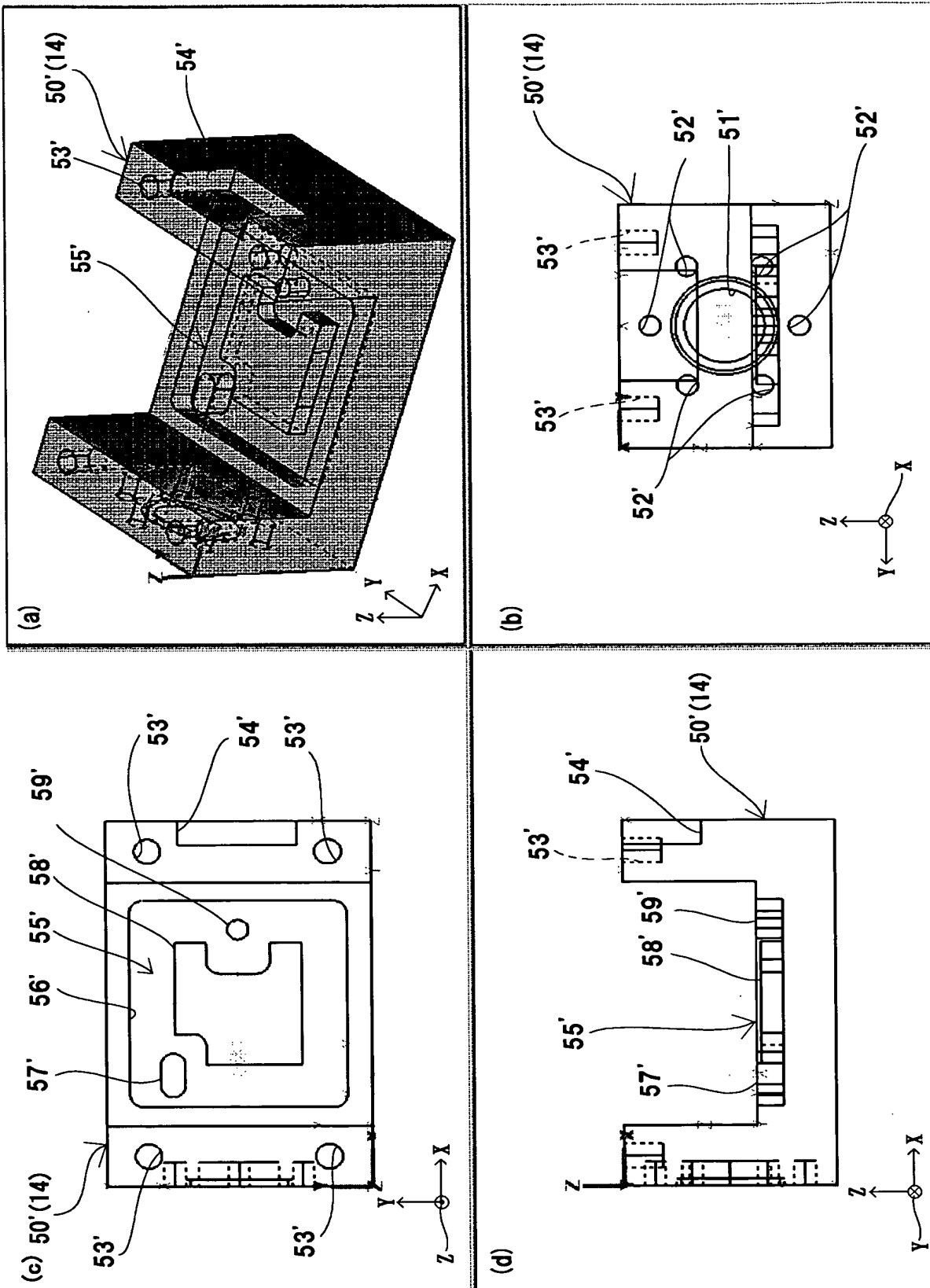
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Fig.3



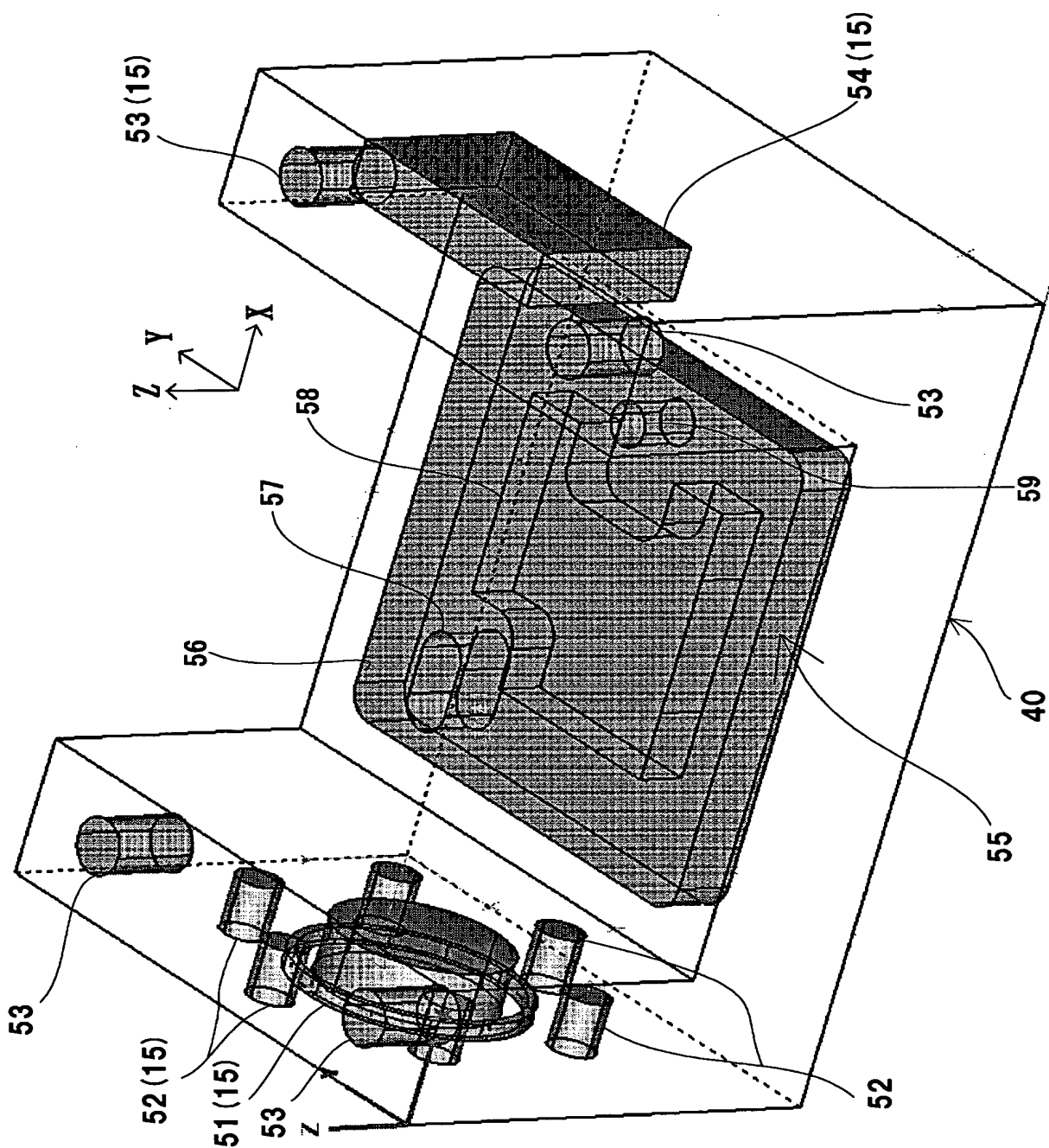
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Fig.4



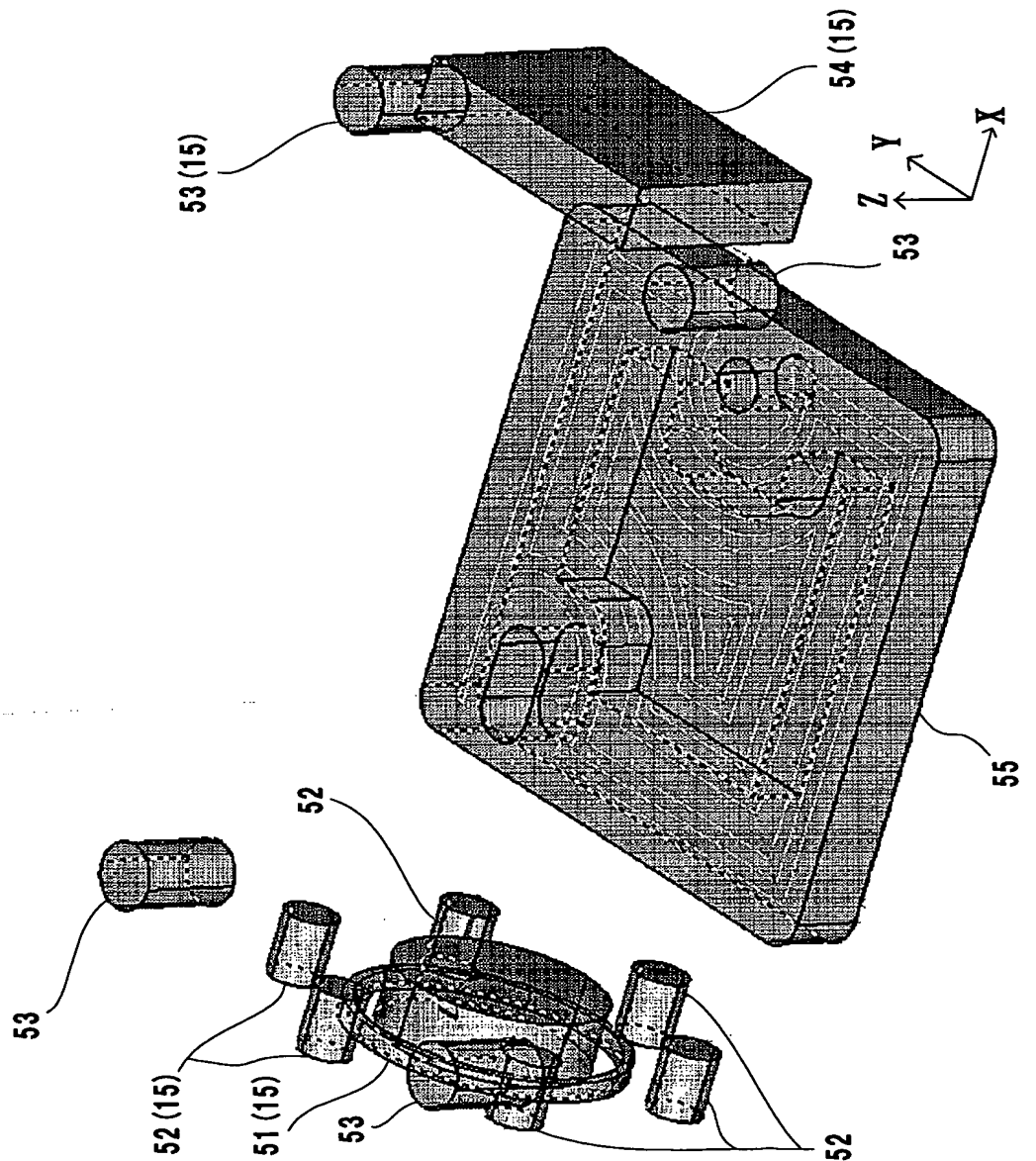
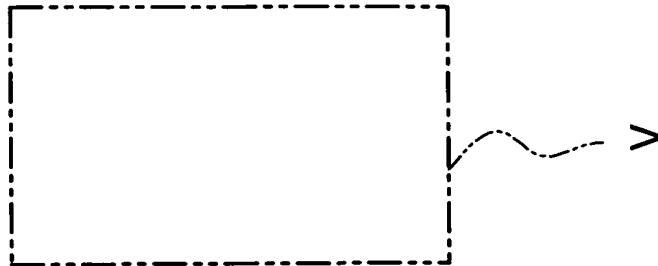
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Fig.5



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Fig.6



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Fig.7

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Tool List

No	Tool Name	Diameter	Surface	MachiningNo.
1	Center drill	3,000	0	1
2	Center drill	3,000	0	2
3	Center drill	3,000	2	4
4	Center drill	3,000	2	5
5	Drill (High speed)	8,000	2	4
6	Drill (High speed)	8,000	2	5
7	Drill (High speed)	9,000	0	1
8	Drill (High speed)	10,000	0	2
9	Drill (High speed)	10,000	0	2
10	Drill (High speed)	20,000	2	5
11	Mill drill	9,500	0	1
12	rough-mil	10,000	0	2
13	rough-mil	10,000	0	2
14	rough-mil	10,000	0	2
15	rough-mil	10,000	0	2

☐ Tool
 ☐ Surface
 ☐ Machining

Type of machining	Pocket making
Sub Number	0
Step	50,000
Relief	50,000
Machining Depth	1,667
Approach speed	100,000
Cutting speed	100,000
Offset direction	Left ▼
User definition	

☐ Keep display
 ☐ Display tools

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Fig.8

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List of Selected Tools

	Tool Name	Diameter	Machining diameter	Machining depth
1	Center drill	3,000	3,000	3,000
2	Drill (Highspeed)	9,000	9,000	17,600
3	Mill drill	9,500	9,500	15,000
4	Reamer (Highspeed)	10,000	10,000	15,000

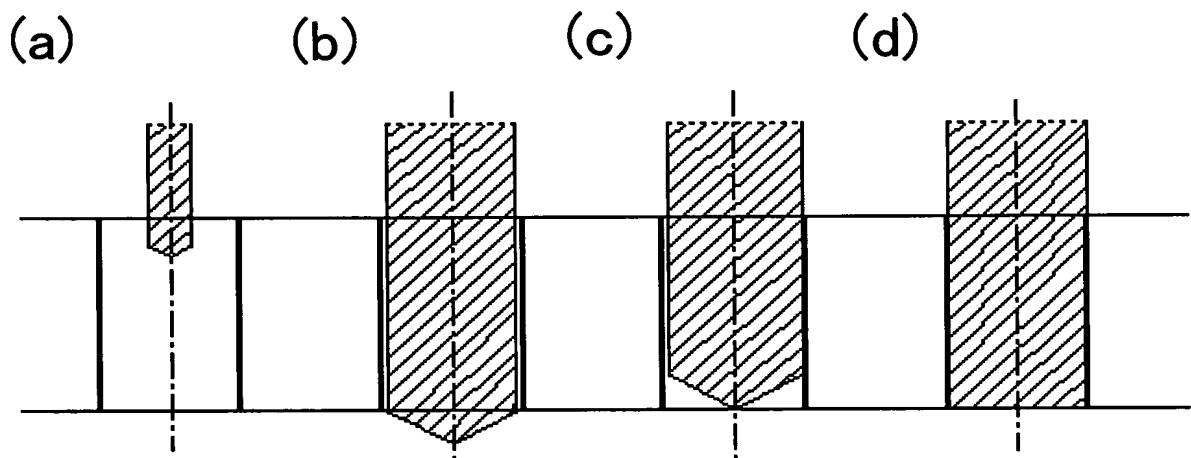
OK

Cancel

Add

Delete

Fig.9



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Fig.10

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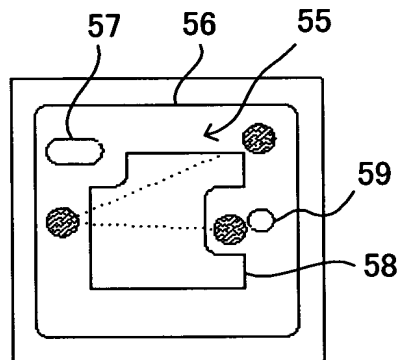
Profile: Re-machining

	Operation	
1	Start-hole drilling	▼
2	Pocket making	▼
3	Removing uncut part	▼
4	Outlining	▼

Add operation    Delete operation    Begin operation

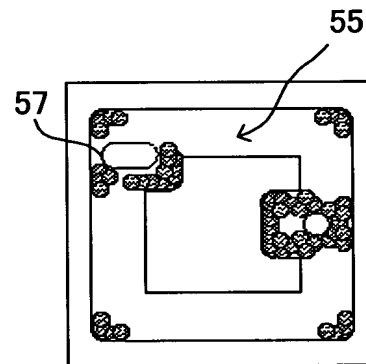
Fig.11

(a)



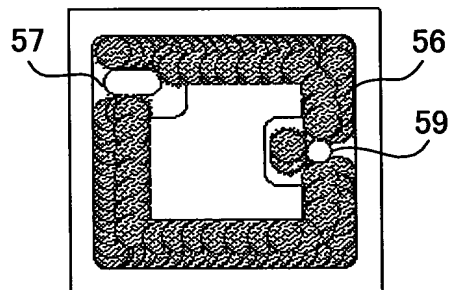
Start-hole drilling

(c)



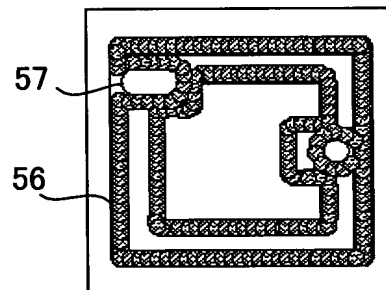
Removing uncut part

(b)



Pocket making

(d)



Outlining



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Fig.12

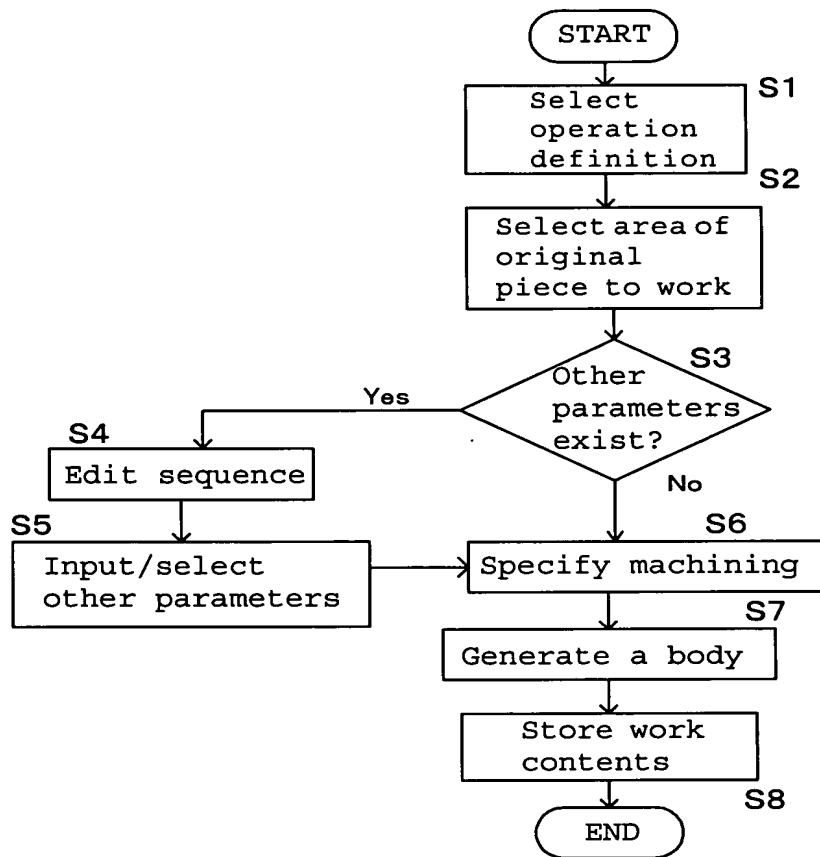


Fig.13

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**Hole Finishing Tool Selection**

☒ First step: Diameter (mm)

☒ Top Surface 10,000

Drilling (High speed) ▼

☐  ▼

☐  ▼

Drill (High speed) 9.000 9.000

Edit sequence

☒ Hole    Number of holes: 4

Start machining

75b

75a

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Fig.14

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**List of Selected Tools** ✕

	Tool Name	Tool diameter	Machining diameter	Machining depth	Drilling depth per cycle [PC]
1	Center drill	3,000	3,000	3,000	3,000
2	Drill (High speed)	9,000	9,000	17,600	17,600

Add tool
Delete tool
OK

Return to machining condition entry

76a                      76b

Fig.15

